

SPLIT

Dart Aerospace Ltd.

Date: Tuesday, 10/06/2008 10:53:49 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 39768
Estimate Number : 12403
P.O. Number :
This Issue : 10/06/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SMALL / MED FAB
Previous Run : 38432
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 06-05-04 JLM
Est Rev:B New process 06-05-05 EC

Drawing Name : WEARPLATE
Part Number : D3511041 BX
Drawing Number : D3511 REV A
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 17/06/2008
Qty: 10 Um: Each

(4)

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S188 304 SHEET .188" THICK



Comment: Qty.: 1.5572 sf(s)/Unit
304 SHEET .188" THICK
(M304S0188)
Batch: 107875 IB 8-6-10

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3511
Dwg Rev: A
Prog Rev: A
2-Deburr if necessary
Identify as D3511-1

IB 8-6-10
IB 8-6-10

(14)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-6-10

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 08/06/10

(44) count



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39768

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D35031

Cup



11x B46994
21x B47461



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

CUP

Batch: B 38283-54x → B 39790-26

EL 9-4-27 (x3)
08-06-16

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend fwd 90 deg. bend per dwg D3511

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/06/11 (14)
08/06/10 (x14)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3511

~~11x B46994~~

11x

A/R SS ROD Batch: H 107051

08-06- EL 9-5-12 (x4)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3511

SB 09/25/14 (14)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-05-13

(x4)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/14 (x4)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

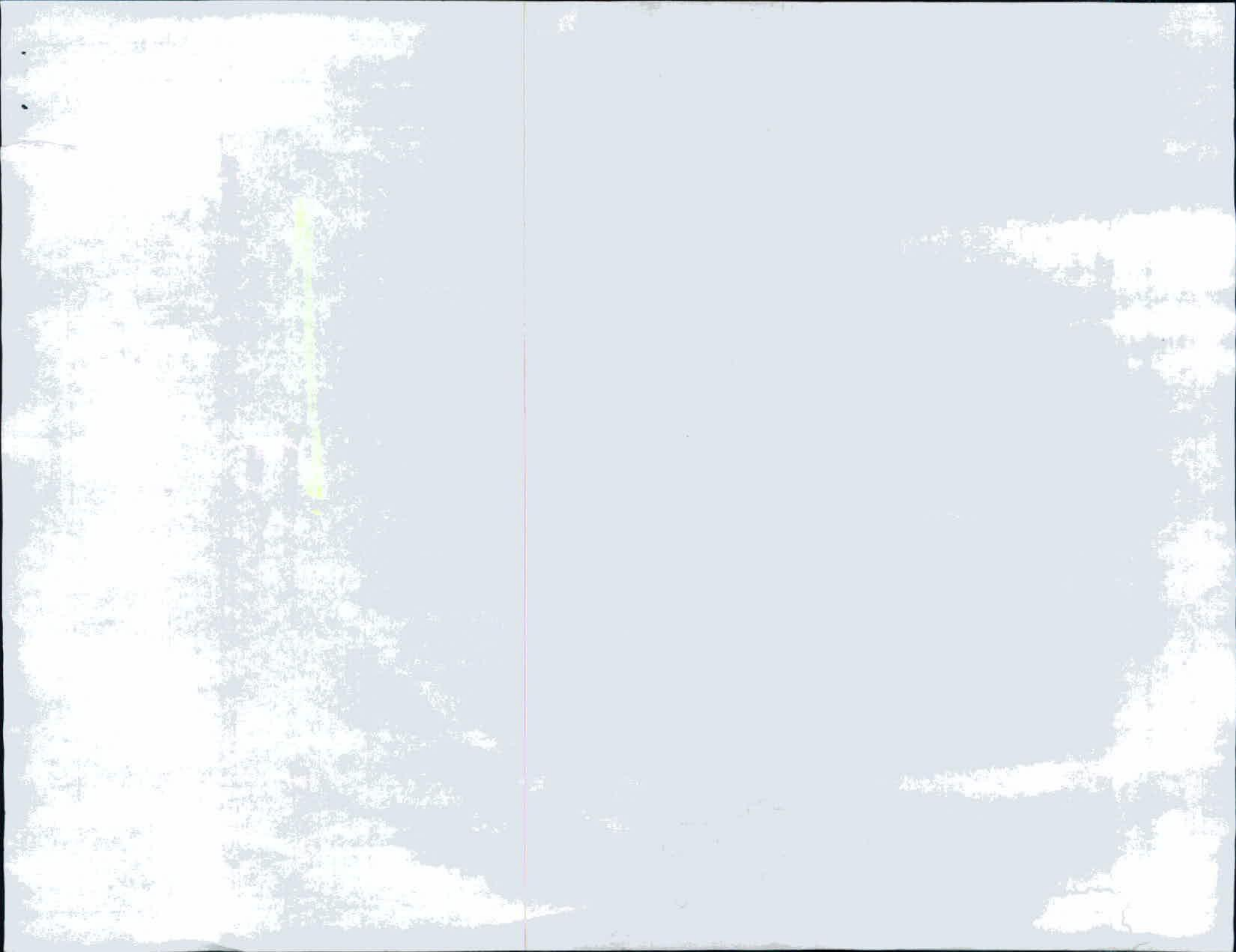
m109091

START TIME:

11310

MD 09/05/20

(x4)



Date: Tuesday, 10/06/2008 10:53:49 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39768

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 3200

FINISH TIME: 11:40

MD 09/05/00

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-10

MD

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

qksta

MD

MD

15.0

QC21

FINAL INSPECTION/W/O RELEASE



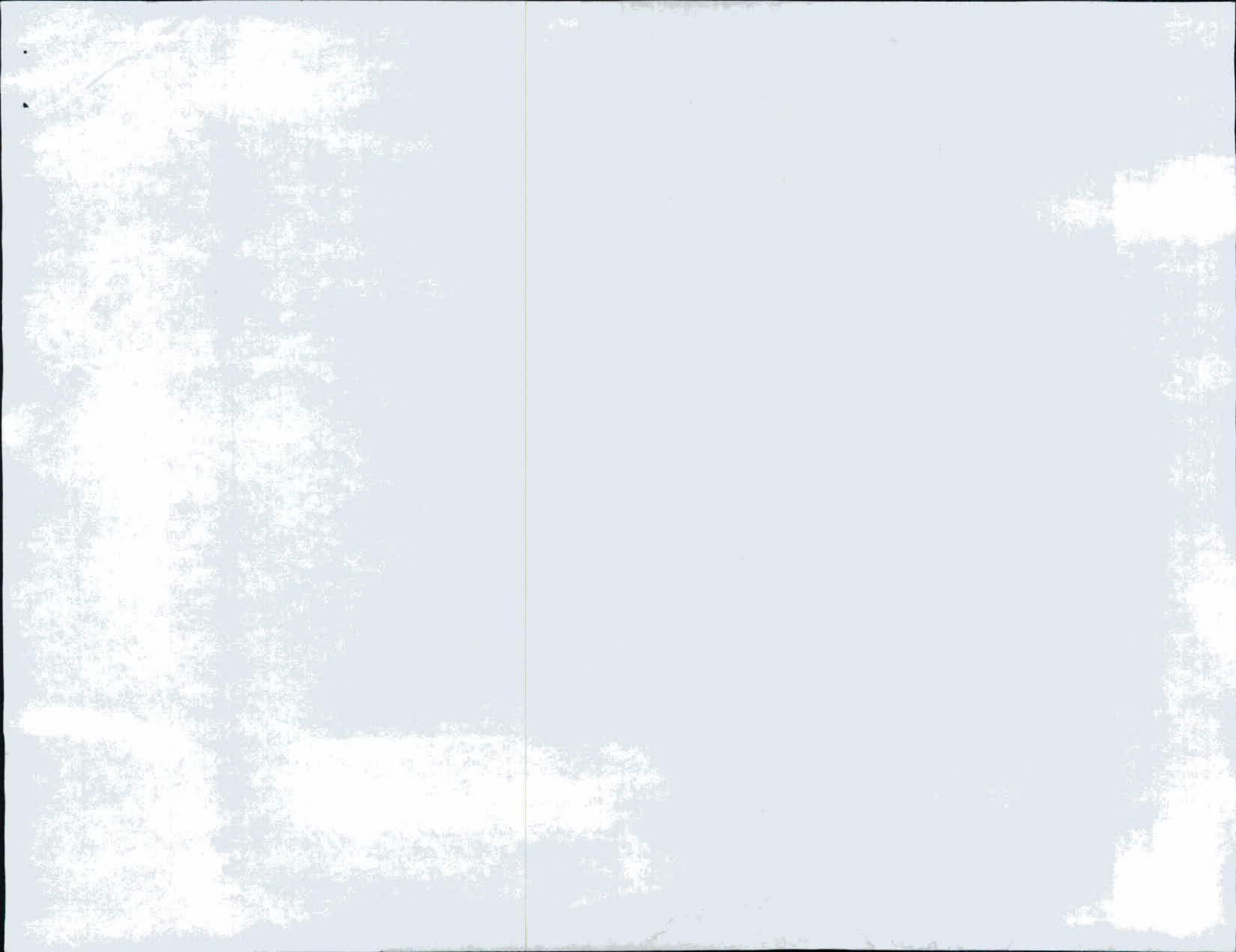
Comment: FINAL INSPECTION/W/O RELEASE

09/05/10

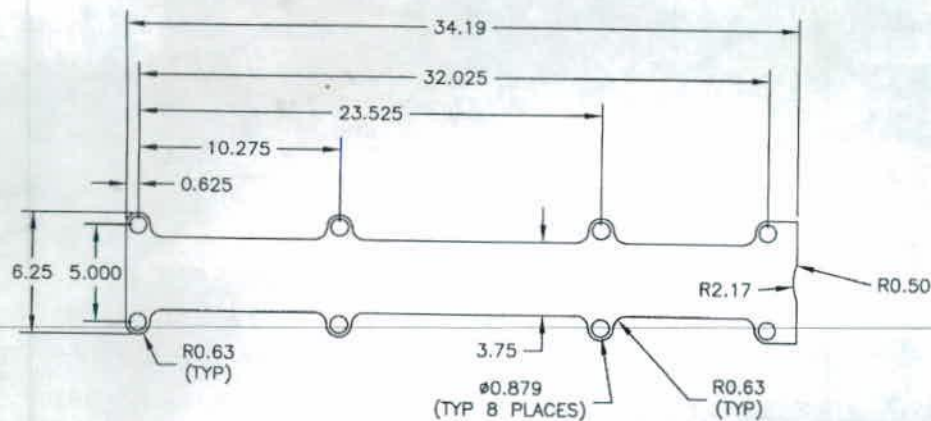
Job Completion



MF 09-05-21

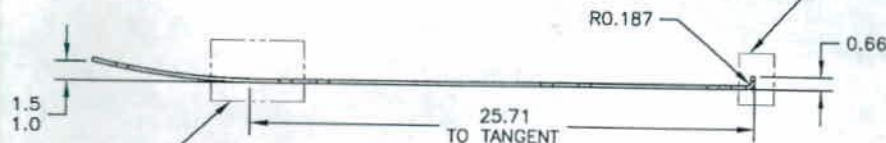






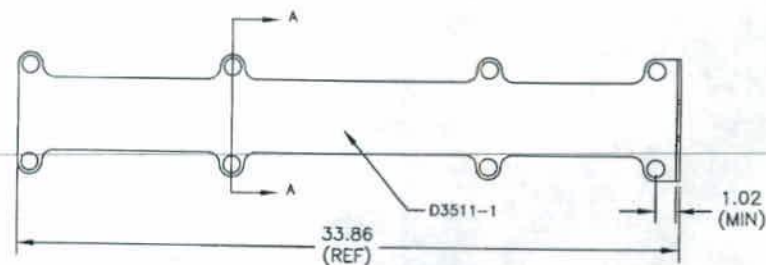
D3511-1F FLAT PATTERN

NOTE: BEND BEFORE WELDING



D3511-1 BEND DETAIL

NOTE: BEND AFTER WELDING



SECTION A-A

D3511-041 WELD DETAIL

D3511-041 WEARPLATE ASSEMBLY

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

D3511-041 WEARPLATE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
8	D3503-1	CUP

RELEASED

06 04 25 #

COPYRIGHT © 2008 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

A	06.04.04	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	JH	APPROVED
DATE	06.04.04	
DART	DART AEROSPACE LTD.	
DRAWING NO.	D3511	REV. A
TITLE	WEARPLATE	SCALE
		NTS

SHEET 1 OF 1

